

Work Order ID 72065

Tuesday, July 19, 2011 7:53:00 AM

RUSH



Page 1

Item ID: D3637-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 7/19/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan:

H

Date: *11-07-19* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3637

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 ☐ Dwg Rev: *B* ☐ Prog Rev: ☐ 2-
Deburr if necessary

11/07/21

16

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/07/21

16

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11 07 21 *16*
Counted

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Form as per Dwg D3637

SB 11/6/27

16

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

11

07

27

16

150

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- drill holes as per dwg using DT8979□2- c'sink holes as per dwg□3-deburr

SB 11/6/27

16

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Required Date: 7/26/2011 Req'd Qty: 16.00

Cust Item ID:

Customer:


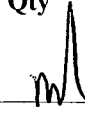


Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00					11	07	27 (16)
170  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				16	0	BA	11-7-27.
180  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				16	0	11	07/27

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Page 4

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Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 245A

0.00



Packaging

Memo

0.00

Packaging

11/7/28 160

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/28

11-07-28 16

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 7:53:06 AM

Page 1

Work Order ID: 72065

Parent Item: D3637-3

Parent Item Name: Bracket




Start Date: 7/19/2011

Start Qty: 16.00

Required Date: 7/26/2011

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050 		Purchased	No			100	sf	106.5000	0.134	2.256842			

2024-T3 .050 sheet

Location

MAT22

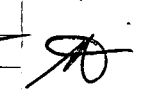
117684

Loc Qty

106.5

106.5

Loc Code

2.5  11/07/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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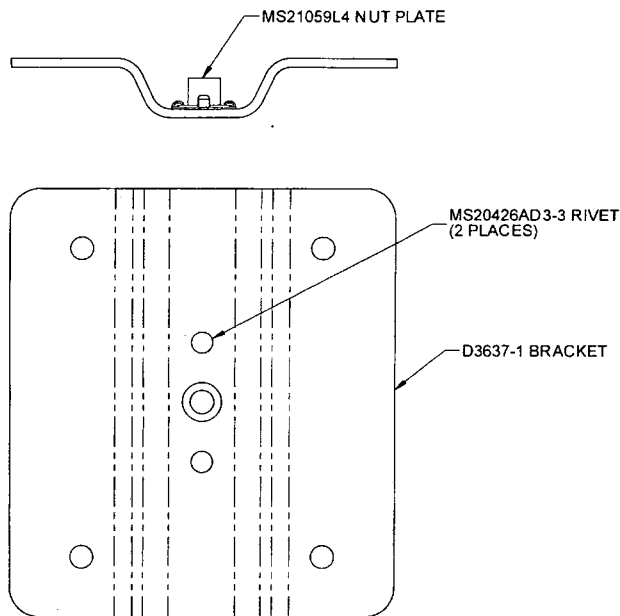
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D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

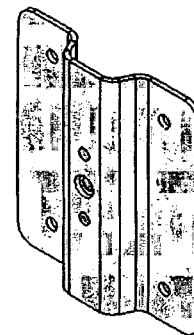
D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12065
P1110719



B	FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JS		
DRAWN	LE		
CHECKED	PE		
MFG. APPR.	EP		
APPROVED	AP		
DE APPR.	TH		
DATE	07.12.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3637** REV. B
TITLE **BRACKET** SCALE 1:1
SHEET 1 OF 3

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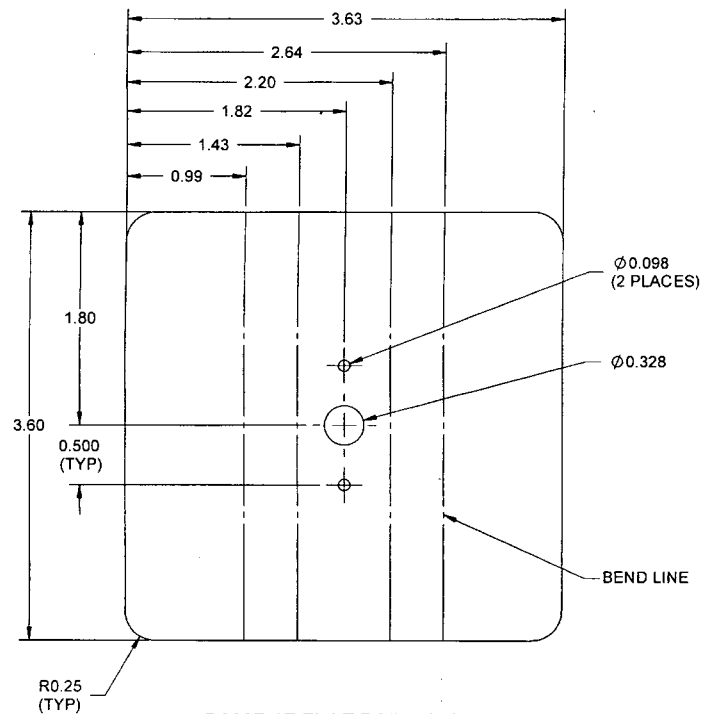
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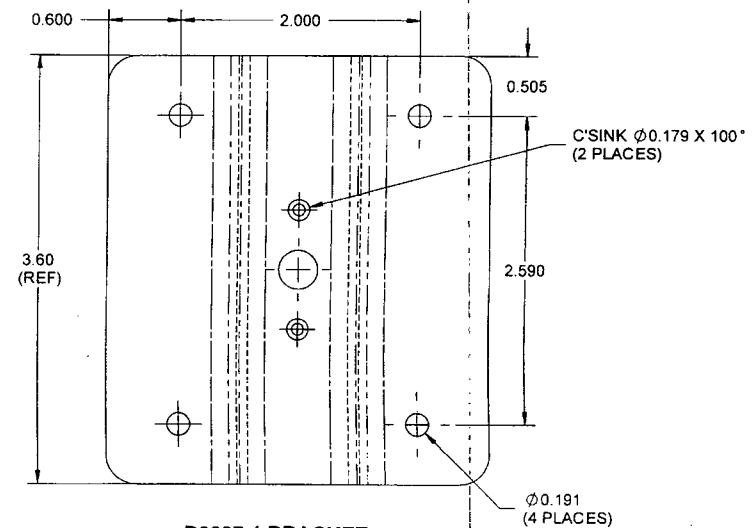
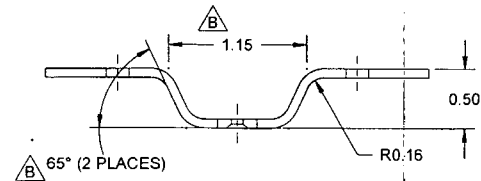
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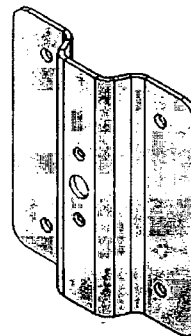
D3637-1F FLAT PATTERN

D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**



DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3637	SHEET 2 OF 3
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	BRACKET	1:1
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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RELEASED
08-22-05

12065

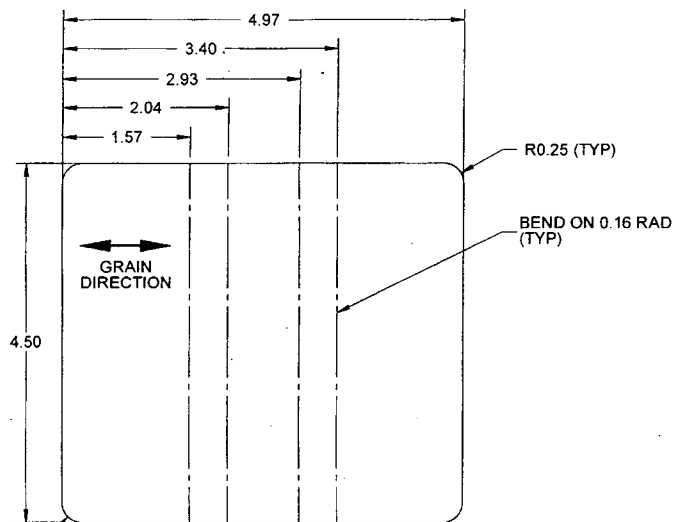
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

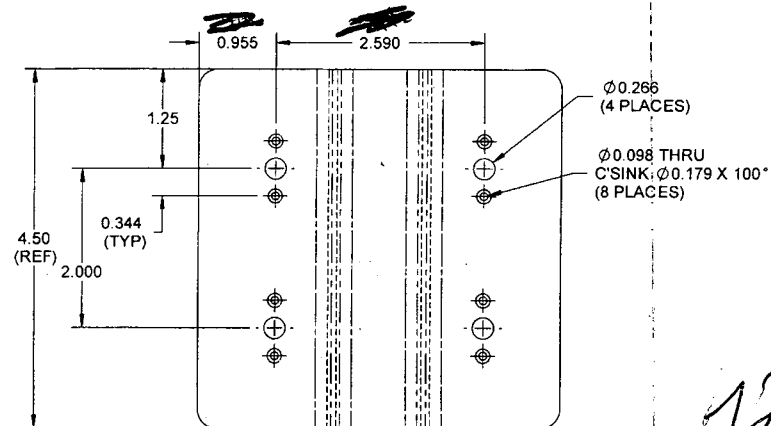
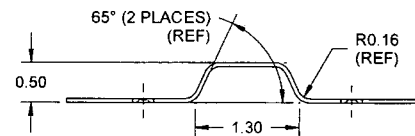
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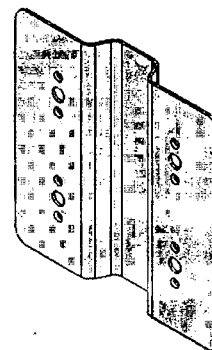
NOTE: Date & initial all entries



D3637-3F FLAT PATTERN



D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PE	DRAWING NO.	REV. B
MFG. APPR.	PE	D3637	SHEET 3 OF 3
APPROVED	PE	TITLE	SCALE
DE APPR.	PE	BRACKET	2:3
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